Work Order ID 96703

January-31-13 9:55:42 AM

96703

BLUE

Item ID: Revision ID:	D2939-1			Accept	*N0	20007	LN1N	n* s	Setup Star	*N	S1*
Item Name:	Saddle LH II	ո, 206		·				•	Stop	• *N I	C 2*
Start Date: Required Date: Reference:	1/31/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*	**		t Item ID: tomer:	v.				. 1/
Approvals:	Process Pl	lan: MUS		Tooling:		Date:		F	Run Star	^t *N	R1*
	QC:		Date:			Date:			Stop	• *NI	.、. ロク*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	To	ool ID To	ol# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr						i de la companya de l			
D2939	Re	v C									
*100 *100* HAAS.1		HAAS CNC VERTICAL	MACHINING #1	0.00		Ph 13.	102/10	_ 12	Ø_		
HAAS CNC vertical	I machine #1	Program part number are p inspect as per	number and batch number rogrammed correctly.2-Mar dwg D2939 & attached D visually inspect as per	:1-Inspect part number a achine Step No 1 of Folio	and visually				,		
110				0.00							
110	•	CONVENTIONAL MILL	ING MACHINE		P	0 3/02	10	12	Ø		
Mill Conv Conventional Millin	g Machine	Mem o Machine Key	way and inspect per attach	0.00 ed dimension sheet	•			16_	<u>y</u>		· — —
			,								
120		QC1- Inspect dimensions	to dimension sheet	0.00							
120					0.	. 7 / -	,	12	(X		
QC Quality Control		Memo		0.00	60	13/02/	10	12_	<i>-</i>		

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

												QA Closed:	Date	2:	
Work Orde	er:					DISPOSITION			i i		AGAINST DE	PARTMENT	PROCESS		
Part N	٠ ، No					Rework Scrap Use-as-is Work Order Update			Skid-tu Machini noformi Large F	ing	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineeri Qual Oth	ity
Root					Descri	ption of work order update		nitial		Ad	ction	Sign &			
Cause		Date	Step	Qty	1	or Non-conformance	Ch	ief Eng	<u></u>	Desc	cription	Date	Verification	QC Insp	ector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training													·		
Unapproved			<u> </u>	l	<u> </u>	F	AUL	T CATE	GORY]		
Landi	ng (Gear		· · · · · ·		General									
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W Turning S	Crimped at n Strip in a Bend Vaves in E equence	Tube Extrusio		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruc Mainto Mislabo Misrea Offset Out of Out of	tion Inco tions Inc enance elecl d Cal brati Sequenc	omplete on ee	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Formatter Temperatur Weld Wrong Stoc	e/Cure
		Wave/Tw	ist in Tul	be		Folio		Outsid	e Dimen	sions					

HandFinish

Hand Finishing

January-31-13 9:55:42 AM Item ID: D2939-1 Accept *N900040100* Setup Start Revision ID: Item Name: Saddle LH In. 206 Start Date: *12* 1/31/13 **Start Qty: 12.00** Cust Item ID: Required Date: 2/22/13 Reg'd Otv: 12.00 *12* **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Otv Otv Number Stamp 130 QC8- Inspect parts - second check 0.00 SAC 13/02/11 *130* 08 oc. 0.00 Memo **Quality Control** 140 Chemical Conversion Coat per QSI005 4.1 0.00 *140*

0.00

Memo

		DQA:	Date:	
ICR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

		. <u> </u>			·						QA Closed:	Dat	te:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N	- lo					Rework Scrap Use-as-is Work Order Update			Skici-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			ļ		Descri	ption of work order update		nitial	A	ction	Sign &		
Cause	1	Date	Step	Qty	ì	or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	n QC Inspector
Doc/Data		•											
Equip/Tooling						•							
Operator				1			İ		П				
Material													
Setup .													
Other .													
Process													
Supplier] .										
Training	_												
Unapproved										· · · · · · · · · · · · · · · · · · ·			<u> </u>
							AUL	T CATE	GORY				
Landin						General		1	T.	 	٦	1	
	_	Bending			,	Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	_	<u> </u>	Over/Under		Temperature/Cure
	_	Cracks			-	Broken/Damaged	-	1	ion incomplete	,, <u> </u>	Part Incorre	,	Weld
	$\overline{}$	Crushed/	Crimped.		 _	Burrs	-	ł	ions Incomplete	/Unclear	Part Lost/M	-	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	-	Mainte		<u> </u>	Part Moved		
	_	Heat Trea		- 1	<u> </u>	Countersink	\vdash	Mislabe	1	ļ	Positioned \	· .	Other
	-	Inspection		Tube		Cut Too Short	\vdash	Misread	י נ	<u></u>	Power Loss/	Surge	Other
	_	Ripples in		·		Drill Holes	-	Offset	Calibantian				
	_	Torque W			n	Drawing	\vdash	4	Calibration		-		
	$\overline{}$	Turning S			 -	Finish	-	1	Sequence				
i 1	ľ	Wave/Tw	rist in Tul	oe –	1	Folio	-1	Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

January-31-13 9:55:42 AM Item ID: D2939-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Saddle LH In, 206 **Start Date:** 1/31/13 **Start Qty: 12.00 Cust Item ID:** Required Date: 2/22/13 Req'd Qty: 12.00 *12* **Customer:** Reference: Run Process Plan: Approvals: Date: ____ Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 145 0.00 *145* 12 0 0 SprayPaint Memo 0.00 **Spray Painting** PRIME B 117319 START: 6:00 FINISH: 6:45 DELFLEET BLUE B 121722 DELFLEET CLEAR B 118093 START: 12:45 FINISH: 1:30 155 QC14- Inspect Spray Paint 0.00 *155* QC

0.00

Memo

NCR:	Yes	/	No

Date:

DQA:

NCR: Y	es / No				WORK ORDER NON-C	CONFOR	MANCE / UP	DAIL	QA Closed:	Date	e:
Work Orde	·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap	4	Skid-tube Machining	Crosstube Small Fab		Water Jet	Engineering Quality
NCR N	0			 	Use-as-is Work Order Update	Ineri	noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator	_										
Material											
Setup											
Other											
Process								•			
Supplier											
Training Unapproved											
onapproved			<u> </u>		F	AULT CATE	GORY		<u>I </u>	<u> </u>	
Landir	ng Gear				General		· · ·				
	Bending				Bend	Grain			Ovalized	Γ	Pressure/Forced
ļ	Centre No	ot Conce	ntric to (o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
Ì	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
Ī	Crushed/	Crimped			Burrs	Instruc	tions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
Ī	Cuffs				Contamination	Maint	enarice		Part Moved	_	
Ī	Heat Trea	at			Countersink	Mislab	eled		Positioned \	Vrong _	
ľ	Inspection	n Strip in	Tube		Cut Too Short	Misrea	ıd		Power Loss/	′Surge	Other
Ī	Ripples in	Bend			Drill Holes	Offset					
Ţ	Torque W	aves in I	Extrusio	n [Drawing	Out of	Calibration				
	Turning S	equence			Finish	Out of	Sequence				· · · · · · · · · · · · · · · · · · ·
	Wave/Tw	ist in Tul	oe		Folio	Outsid	e Dimensions				

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January-31-13 9:55:42 AM

Page 4

Item ID: D2939-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Saddle LH In. 206 **Start Date:** 1/31/13 **Start Qty: 12.00** *12* **Cust Item ID:** Required Date: 2/22/13 Req'd Qty: 12.00 **Customer:** Reference: Run **Process Plan:** Approvals: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp 170 Identify as per dwg & Stock Location:_ 0.00 *170* Packaging Memo 0.00 Packaging 180 QC21- Final Inspection - Work Order Release 0.00 *180* Memo 0.00 Quality Control

NCR: Y												
										QA Closed:	Date	2:
Work Orde	r·				DISPOSITION				AGAINST DE	EPARTMENT,	/PROCESS	
Work Orde	۱				Rework	1 I	Skid-tu	ıhe	Crosstube	7	Water Jet	Engineering
Part N	0.				Scrap	1	Machin	—	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Th	ermoform	~⊢	Finishing	-4	re/Packaging	Other
NCR N	o			·····	Work Order Update]	Large F	~	Composite]	Supplier	
Root	1	!	· · · · · · · · · · · · · · · · · · ·	Descri	ption of work order update	Initia	1 1	Δct	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	i		ription	Date	Verification	QC Inspector
Doc/Data	Date	Эсер	4.5		or non comormance	- Cinc. E			.,,			
quip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training						1						
Jnapproved						ļ <u></u>				<u> </u>		
						AULT CA	TEGORY					
Landir	ng Gear				General					- 7	_	-]
]	Bending				Bend	Gra			<u> </u>	Ovalized	-	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	⊢ ⊣	dware		-	Over/Under	<u> </u>	Temperature/Cure
	Cracks			_	Broken/Damaged	⊢ –	ection Inco	•		Part Incorre	<u> </u>	Weld
	Crushed/	Crimped.		<u> </u>	Burrs	—	ructions Inc	complete/	Unclear	Part Lost/M	_	Wrong Stock Pulled
-	Cuffs			<u> </u>	Contamination		intenarice		<u> </u>	Part Moved		
-	Heat Trea		+ .	-	Countersink	\vdash	labeled		<u> </u>	Positioned \		Othor
-	Inspectio	•	Tube		Cut Too Short	├ ──┤	read		L	Power Loss,	Surge	Other
}	Ripples in		. •	_	Drill Holes	Offs		ion				
-	Torque W			` -	Drawing	⊢	of Calibrati					
1	Turning S	equence			Finish	Out	of Sequence	ce				

Outside Dirnensions

DQA:

Date:

Wave/Twist in Tube

Folio

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Picklist Print

January-31-13 9:55:46 AM

Work Order ID: 96703

D2939-1

Parent Item Name: Saddle LH In. 206

96703

D2939-1

Start Date: 1/31/13

Required Date: 2/22/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

Parent Item:

IPP: B00.06.26New DWG rev (mpp 2069)EC

IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No	····		100	Each	83.0000	1	12			
D6101-00)1								**	· · · · · · · · · · · · · · · · · · ·	Po I	3/62/	66

Location	Loc Qty	Loc Code	
MAT040	33		
91236	33		
MAT042	50		
→P 94445	50		12

NCR: Y	es / - No				WORK ORDER NON-	CONF	ORN	MANCE / UPD	DATE	QA Closed:	Date	::
Work Orde	r:				DISPOSITION				AGAINST DE			
Part N					Rework Scrap		ī	Skid-tube Machining	Crosstube Small Fab	4	Water Jet	Engineering Quality
NCR N	o				Use-as-is Work Order Update			oforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	iption of work order update	Initi	al	Acti	ion	Sign &	-	
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling]		
Operator												
Material							İ	•			i	
Setup												
Other												
Process							- 1					
Supplier							ļ	:				
Training												`
Jnapproved												
					F	AULT C	ATE	GORY				
Landin	g Gear				General					_		
	Bending				Bend	Gr	ain			Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to (o/s	BOM/Route	На	rdwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	pecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Ins	tructi	ions Incomplete/L	Inclear	Part Lost/M	ssing	Wrong Stock Pulled
Ī	Cuffs				Contamination	M	ainte	narice		Part Moved	_	
	Heat Trea	at			Countersink	Мі	slabe	led		Positioned \	Vrong	
Ī	Inspectio	n Strip in	Tube		Cut Too Short	Мі	sread	ı		Power Loss/	Surge	Other
Ī	Ripples in				Drill Holes	Of	fset	!		-	_	
	Torque W		xtrusion	n	Drawing	Tou	it of C	Calibration				
Ţ	Turning S				Finish	Пои	it of S	equience				
Ī	Wave/Tw				Folio	Пои	ıtside	Dimensions				

DQA:

Date:

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DART AEROSPACE LTD	Work Order:	96703
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Re	corded Act	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		,110	. 113	.112	5112		
В	0.100	0.140		.112	. 113	.112	. 112		
С	0.100	0.140		-115	- 110	.112	1110		
D	0.210	0.230		- 720	. 220	-216	-216		
E	1.245	1.255		.720 j.280	1,250	1.250	1,250	ļ	
F	1.245	1.255		1.25)	1.250	1.250	1.250 .		
G	2.495	2.505		2,500	7.500	2.500	2.500		
Н	0.510	0.515		.512	SIZ	.512	-SII		
-	1.572	1.582		1.577	1.577	1.577	1.573		
J	2.495	2.505		2.500	2.500	7.500	2.500		
K	0.257	0.262		.258	258	.258	258		
L	0.312	0.317		.34	314	. 314	1314		
M	0.235	0.240		.238	.737	.237	.237		
N	0.100	0.140		-119	120	.117	_ 113		
0	0.540	0.560		, 545	.548	.550	-SSO		
Р	0.490	0.510		. 500	,500	499	्यवव		
Q	3.715	3.725		3.720	3.720	3.720	3,720		
R	2.720	2.760		2.740	2.740	2740	2'.740		
S	0.240	0.270		250	249	,749	. 250		
T	0.100	0.180		. 140	. 140	140	.140		
U	1.625	1.635		1.630	1630	1.639	(,630		
V	1.362	1.372		1367	1.367	1.367	1367		
W	0.316	0.321		:316	-316	.316	:316		
X	1.250	1.270		1,259	1,260	1,260	1,257		
Υ	1.565	1.585	DT8695 A/B	1.577	1.577	1.577	1,574		
Z	0.178	0.198		881.	(88)	182	138		
AA		_	,			1			
AB									
AC									
AD	-								
AE		-							
AF									
AG									
AH									
	Acc	ept/Reje	ct						

•		
Measured by: VD	Audited by D	
Date: 13/02/10	Date: (3)	02 11
		•

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	21
С	07.03.21	Revised per drawing revision C	KJ/JLM 🚓	411

DART AEROSPACE LTD	Work Order:	96703
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1/5	26	37	18	Ву	Date
Α	0.100	0.140		oill	-112	-112			
В	0.100	0.140		- 111	. 112	112	111		
С	0.100	0.140		. 110	. 109	109	-109		
D	0.210	0.230		.217	. 220	0217	. 216		
E	1.245	1.255		1.250	1250	1.250	1,250		
F	1.245	1.255		1.250	1.250	1.750	1,250		
G	2.495	2.505		2.500	7.500	2.500	7,500		
Н	0.510	0.515		.512	.512	. 512	.512		
	1.572	1.582		1.577	(.S77	1517	1.577		
J	2.495	2.505		250	7.500	2.500	2.500		
K	0.257	0.262		.258	,25K	.258	258		
L.	0.312	0.317		- 314	.314	.314	.314		
M	0.235	0.240		. 237	.237	. 237	.236		
N	0.100	0.140		118	. 122	118	.117		
0	0.540	0.560		.550	551	/5SI	, 550		
Р	0.490	0.510		. 499	. 497	.499	•498		V
Q	3.715	3.725		3.720	3.700	3.720	3.720		
R	2.720	2.760		2.740	2 740	2 740	2.740		
S	0.240	0.270		749	248	.248	249		
Т	0.100	0.180		•140	.140	140	140		
U	1.625	1.635		1.630	1.630	1.630	1,620		
V	1.362	1.372		1 367	1.367	1361	1.367		· · · · · ·
W	0.316	0.321			-316	46	36		
X	1.250	1.270		1,259	1.264	1,260	.316		
Υ	1.565	1.585	DT8695 A/B	1,576	1591	1:577	1.577		· · · · · ·
Ζ	0.178	0.198		USS	881.	188	-138		
AA				09	04	. 1 470	- 120		
AB									***
AC									
AD						···· \			·
AE									
AF									
AG									
AH									
	Acc	ept/Reje	ct						

Measured by: 90	Audited by	Ha	U U
	7 taantaa by	<u> </u>	
Date: 13 /c1 / 1	Date:	13/02/11	US
346. 1370271	Date.	1310211	
		7	0-77

A New Issue RF B 02.12.12 Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & KJ/RF C 07.03.21 Revised per drawing revision C KI/II M C/L Added Dim. X-Y, DT8683, DT8686, DT8690 & KJ/II M C/L Added Dim. X-Y, DT8683, DT8690 & KJ/II M C/L Added Dim. X-Y, DT8683, DT8690 & KJ/II M C/L Added Dim. X-Y, DT8683, DT8690 & KJ/II M C/L Added Dim. X-Y, DT8683, DT8690 & KJ/II M C/L Added Dim. X-Y, DT8690 & KJ/II M C/L Added	Rev	Date	Change	Revised by	Approved
DT8695 A/B KJ/RF	Α		New Issue	RF	
C 07.03.21 Revised per drawing revision C K.V.II MZL (M)	В	02.12.12		KJ/RF	
110/02/11 5/4/ 1	С	07.03.21	Revised per drawing revision C	KJ/JLM O	

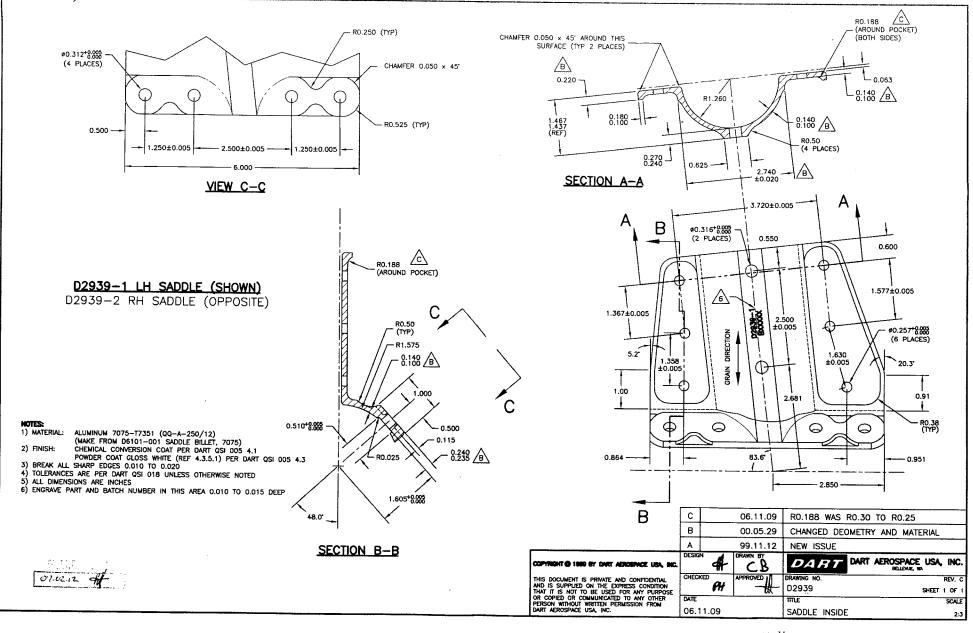
DART AEROSPACE LTD	Work Order:	96703
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Re	corded Act	ual Dimensi	ons	*****	
Dim	Min	Max	Go/No Go Gauge	29	رح ا	28 11	A 12	Ву	Date
Α	0.100	0.140		· 112	-111	.114	.112		
В	0.100	0.140		.112	112	. 44	. 110		
С	0.100	0.140		.112	(11)	. 112	107		
D	0.210	0.230		·219	. 221	4222	22Z		
E	1.245	1.255		1.250	1.250	1.250	222 1,250		
F	1.245	1.255		1,280	1.250	1.250	1150		
G	2.495	2.505		2 500	2.500	2.500	2.500		
Н	0.510	0.515		-517	-512	,512	.512		
	1.572	1.582		1,577	1577	1.577	1.577		
J	2.495	2.505		2,500	2.500	2 500	3.30		
K	0.257	0.262		258	. 258	.258	.258		**
L	0.312	0.317		.314	314	.314	.314		
M	0.235	0.240		. 236	,237	237	-237		
N	0.100	0.140		-120	. 122	.122	123	-	
0	0.540	0.560		,549	, 550	.548	. 550		
Р	0.490	0.510		-500	.497	2495	.497		
Q	3.715	3.725		3,720	3 720	3.720	3.720		
R	2.720	2.760		7.740	9 740	2710	2,740		
S	0.240	0.270		.249	. 249	.249	.249		
T	0.100	0.180		- 140	140	,140	,140		
U	1.625	1.635		1.630	1.630	(.630	1.630		
V	1.362	1.372		1.367	1367	1.367	1267		
W	0.316	0.321		.316	.316	316	316		
X	1.250	1.270		1.261	1,263	1.263	1,263		
Υ	1.565	1.585	DT8695 A/B	1.578	1 580	1.580	(.58)		
Ζ	0.178	0.198		881.	138	+188	(8)		
AA				~ ~			100		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
	Acc	ept/Reje	ct						·····

Measured by: 🔞	Audited by	5-9	DAS	
Date: 13/02/10 N	Date:	13/02/11	08	
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Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	- 1
С	07.03.21	Revised per drawing revision C	KJ/JLM	\(\int_{\ill}\)



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